

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003490**Date Inspected:** 24-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	Tower				

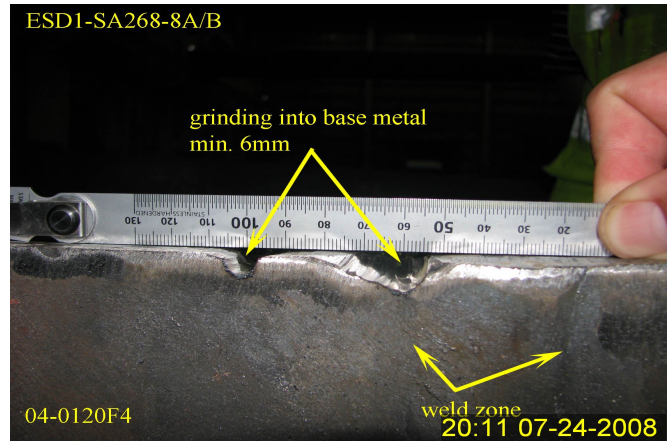
Summary of Items Observed:

UT

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector performed UT verification after ZPMC had completed and accepted the weldments. This QA inspector performed 10 % of the weld lengths for review. At the time of the QA review the weldments appeared to be in conformance The following is a list of weldments reviewed; Tower skin plate E, SSD1-SA173 A/K-13A/B. Tower skin plate C, ESD1-SA77 E/E welds 1~4 A/B and 9~13 A/B, ESD1-SA77 D/E-26and 27A/B. A TL-6027 will be generated for these locations. Also noted for internal diaphragm ring ESD1-SA268-8 A/B this QA inspector observed ZPMC performing grinding at the edge of the plate next to the weldment that extended into the base metal a minimum of 6 mm. ZPMC and ABF was informed of the occurrence and that a Critical Weld Repair would be needed to proceed with this repair as per the contract documents. See digital photo of area below.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

as noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 1-376-471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
